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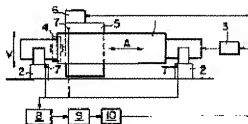
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BEPPU YOSHIMITSU
KAWABATA MITSUO**(54) GRINDING DEVICE FOR ROLLING ROLL**

(57)Abstract:

PROBLEM TO BE SOLVED: To prevent the occurrence of chatter marks such as unevenness in roughness over the surface of a roll, and obtain an uniform surface finishing nature in a grinding work for the rolling roll.

SOLUTION: This grinding device is formed out of vibration sensors 7 provided for a wheel spindle stock 5 or both the wheel spindle stock 5 and a roll receiving stand 2, a frequency analyzing device 8 analyzing a vibration signal detected by the sensors 7, a chatter detection device 9 which compares and operates the level of a vibration value for the distribution of analyzed vibration frequency, and of a chatter detection device which outputs a chatter generation signal when the level of a vibration value is found to have exceeded a threshold value set in advance, or the chatter generation signal is outputted to a revolution speed control pat 10, by gradually increasing or decreasing the revolution speed of a grinding wheel and the revolution speed of a roll with a speed ratio kept constant between the revolution speed of the grinding wheel and the revolution speed of the roll, the surface roughness of the roll 1 is made uniform, and the occurrence of chatter marks coming into question in a surface finishing nature is thereby prevented.

**LEGAL STATUS**

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